

Date: Thursday, 31/07/2008 1:44:41 PM  
User: Julie Lecocq

## Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FRONT RAIL, LH
Job Number :	40863		
Estimate Number :	13492		
P.O. Number :		Part Number :	D37661
This Issue :	31/07/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3766 REV B
First Issue :	31/07/2008	Project Number :	N/A
Previous Run :	40708	Drawing Revision :	B
		Material :	
Written By :		Due Date :	08/08/2008
Checked & Approved By :	<u>[Signature]</u>	Qty:	10 Um: Each
Comment :	Est Rev:A 08-07-21 revB as per dwg DD verified by:EC		

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6T1000W188

6061T6 RD TUBE 1.00 X .188W



Comment: Qty.: 2.9323 f(s)/Unit Total: 20.5263 f(s)

6061T6 RD TUBE 1.00 X .188W

batch: 71104729

SAD 08/08/13

(10)

2.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-cut tube to length as per dwg D3766

SAD 08/08/13

(10)

2-drill holes thru to finish size as per dwg D3766

mmf 08/08/16

3- deburr

SAD 08/08/13

(10)

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 08/08/14

(10)

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 08-08-19

(10)

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAD 08-08-19

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 31/07/2008 1:44:41 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRONT RAIL, LH

Job Number: 40863

Part Number: D37661

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST

MF 08-08-19

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/08/20

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-08-19

**Dart Aerospace Ltd**

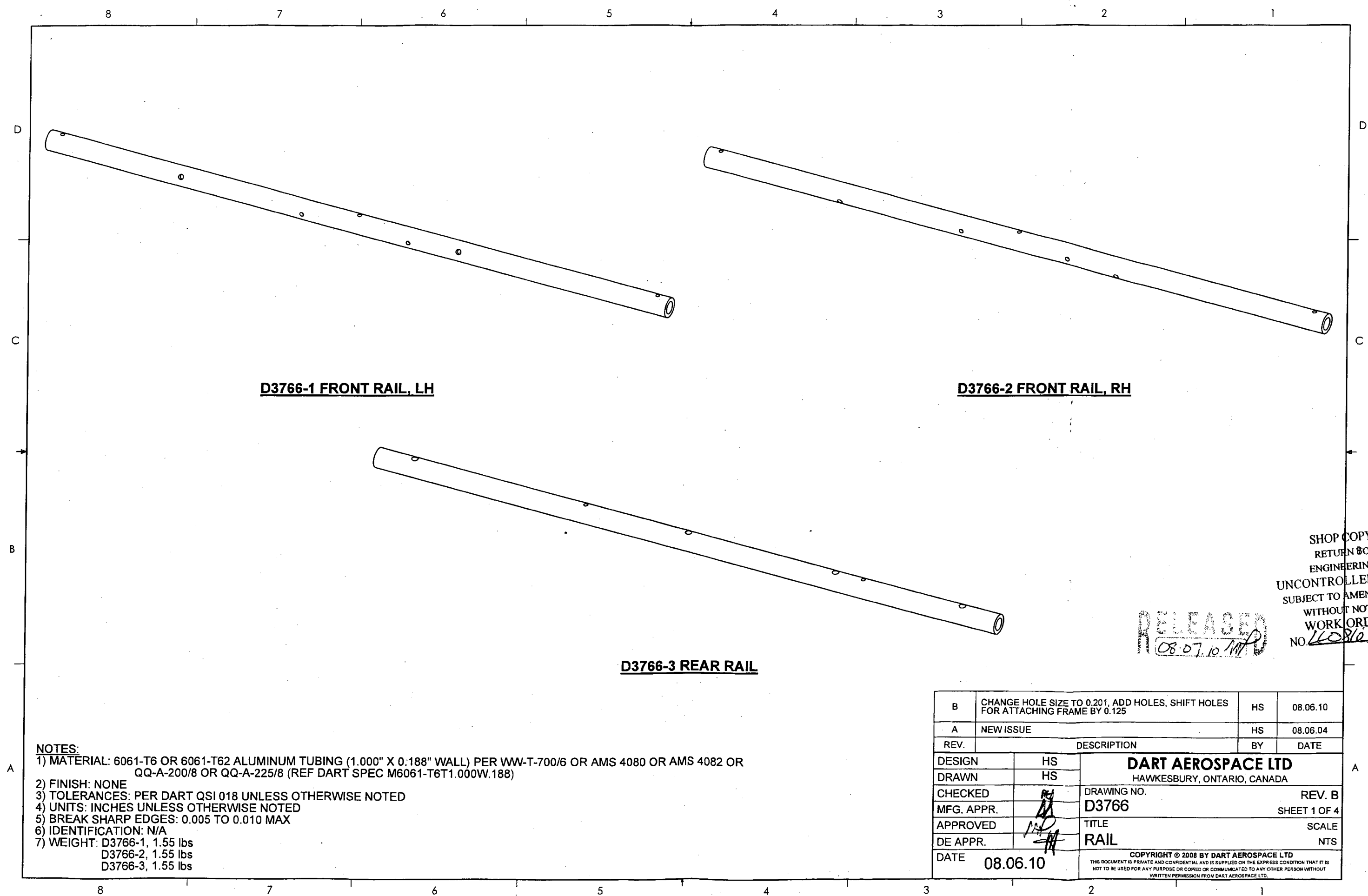
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3766-1 FRONT RAIL, LH**

**D3766-2 FRONT RAIL, RH**

**D3766-3 REAR RAIL**

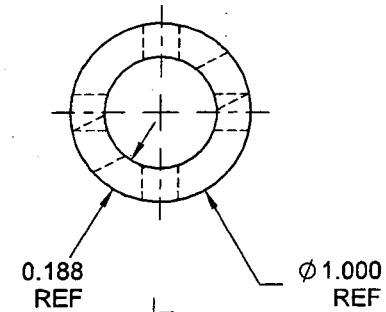
**NOTES:**

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.000" X 0.188" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061-T6T1.000W.188)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3766-1, 1.55 lbs  
D3766-2, 1.55 lbs  
D3766-3, 1.55 lbs

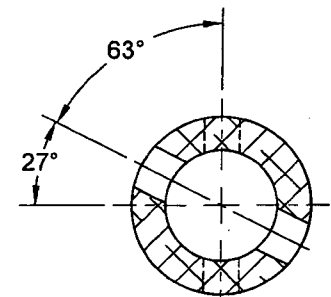
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WORK ORDER  
NO. 4408103

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08.07.10

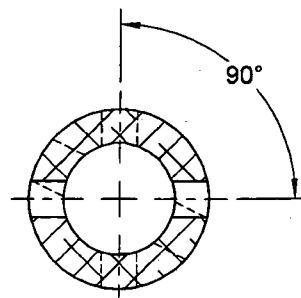
B	CHANGE HOLE SIZE TO 0.201, ADD HOLES, SHIFT HOLES FOR ATTACHING FRAME BY 0.125	HS	08.06.10
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3766	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RAIL	NTS
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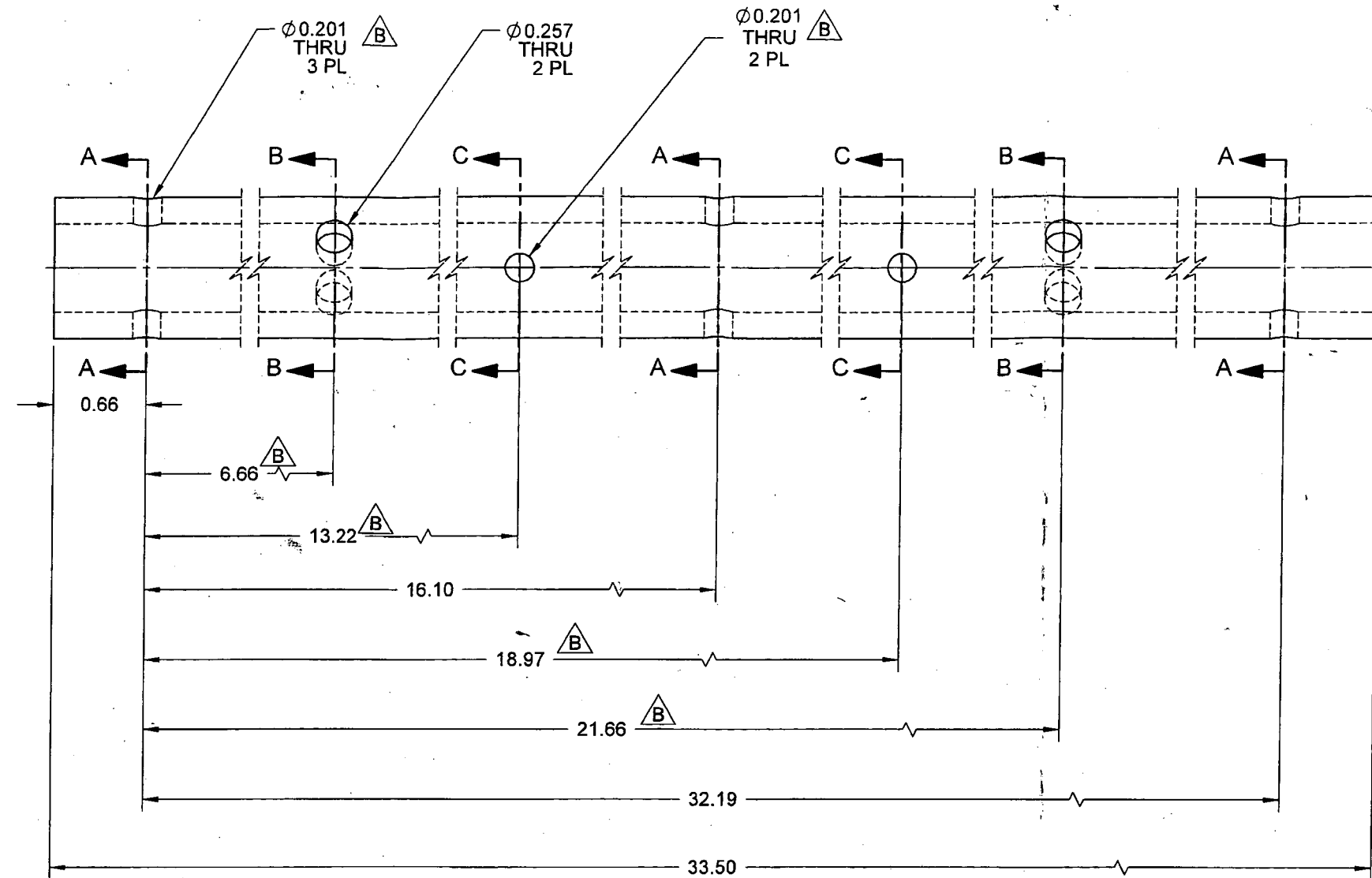
**SECTION A-A**



**SECTION B-B**







**SECTION C-C**

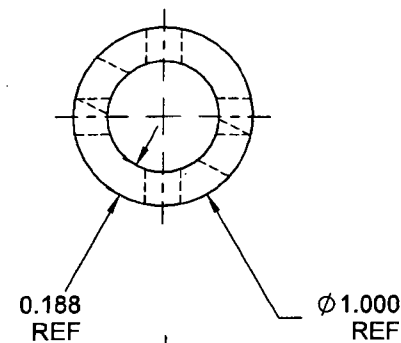


**D3766-1 FRONT RAIL, LH**

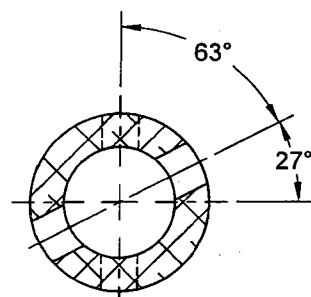
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WORK ORDER  
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08-07-10

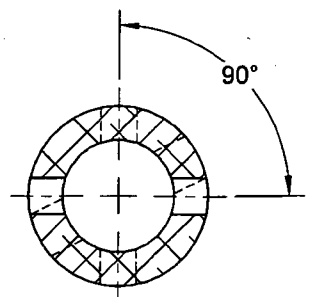
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DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D3766	SHEET 2 OF 4
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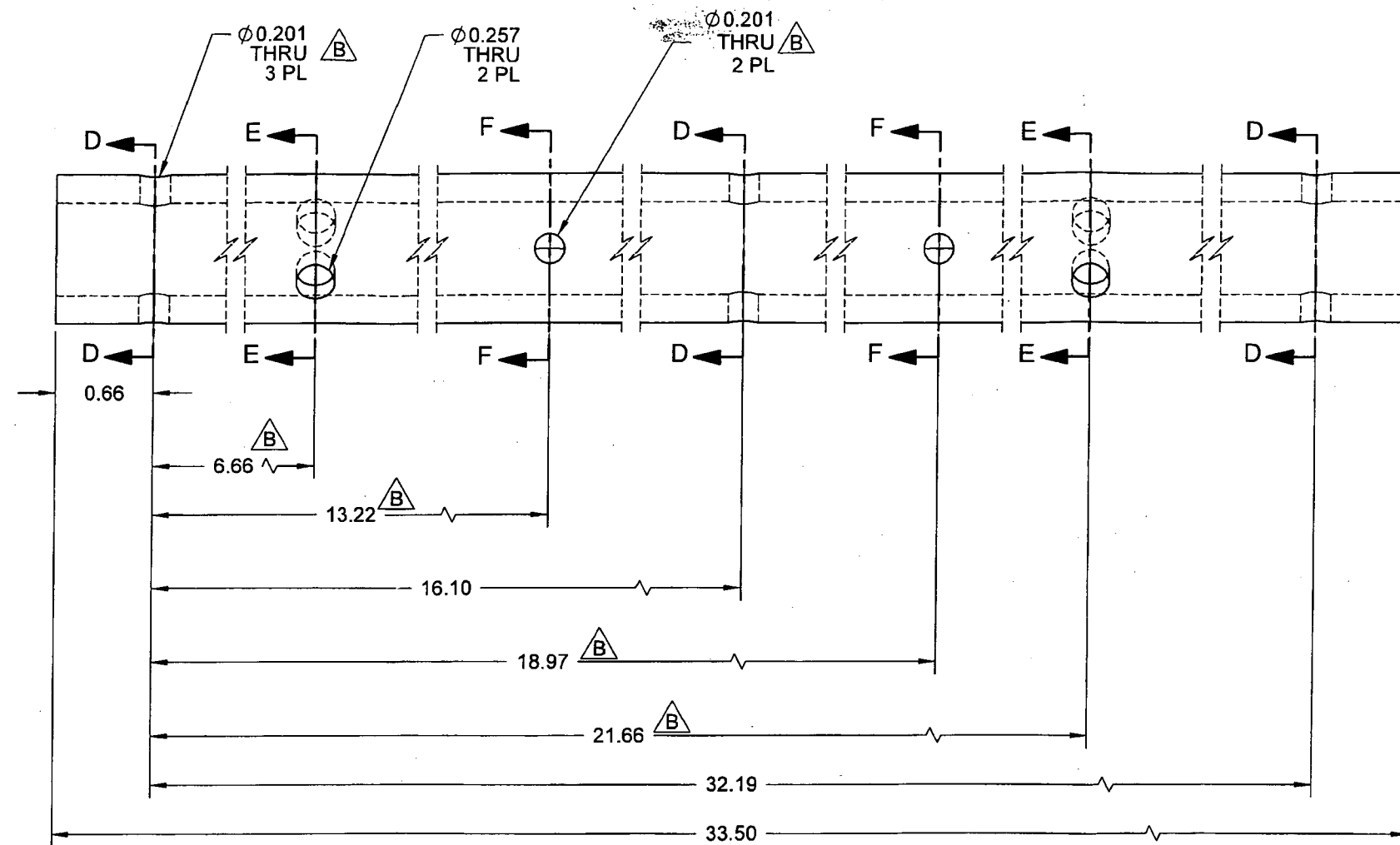
**SECTION D-D**







**SECTION E-E**



**SECTION F-F**



**D3766-2 FRONT RAIL, RH**

DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D3766	SHEET 3 OF 4
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WORK ORDER  
NO. 40863

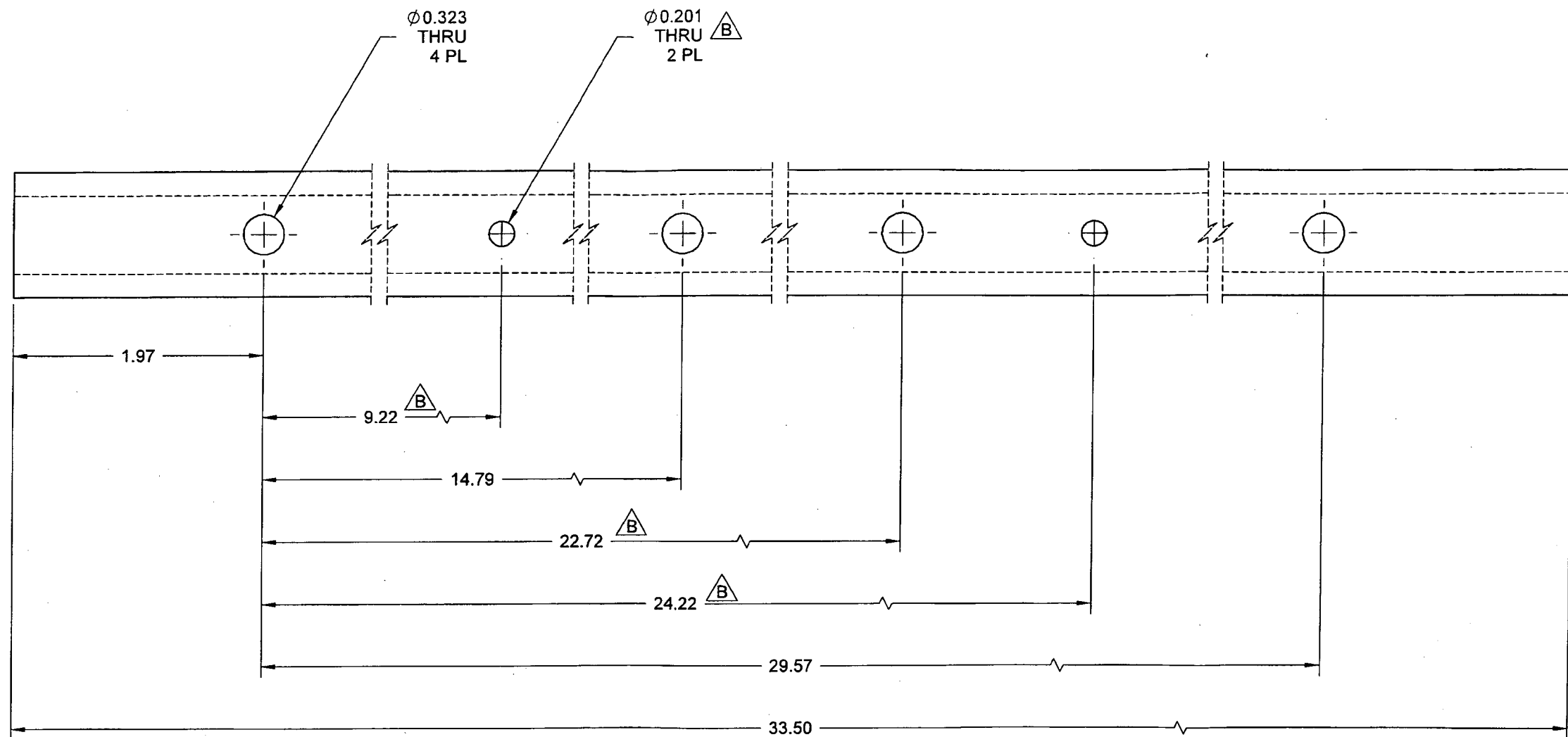
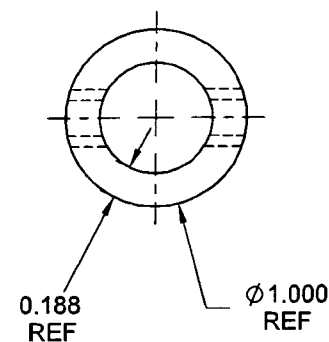
8 7 6 5 4 3 2 1

D

C

B

A



**D3766-3 REAR RAIL**

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 42863

DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3766	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RAIL	NTS
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8 7 6 5 4 3 2 1



